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D2345
Job Sheet 192934



Part No: D2345

Job Qty: 12 pcs

Part Name: Lock Channel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/4/19

Job Tracking No:

Due Date: 4/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPPRevB 99.05.31 Re-format DM IPP Rev:C Now on Waterjet 06-10-26 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		4/26/19	0.00	0.87	Waterjet - Flow		2019/04/16
120	QC 8	12 pcs		4/26/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Small Fab - 2 - B4B	12 pcs		4/26/19	0.00	0.84	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		

DAS
58 APR 9 2019
9-89

DAS
58 APR 9 2019
9-89

CB

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170 QC 21 - SA		12 pcs	4/26/19	0.00 0.00	Packaging 3 - 36 - B4B	QC 21 - SA - 21	21
						QC 21 - SA - 70	8-05
						QC 21 - SA - 53	APR 30 2019

Part Op 100 - 1-Cut as per Dwg D2345
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Small Fab) Deburr if necessary.
 140 - (Form as per dwg) Form as per Dwg D2345 using DT8241 Remove tooling tab and buff flush
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Identify as per dwg & Stock Location: _____) LOCATION : GA
 170 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	.6336 sf (.0528 ea)	100-Waterjet - Flow - 1	S159673 S132620

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	1	196	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lock Channel	2.800Inches ± 0.010	2.810 2.790		
2	Lock Channel	2.520Inches ± 0.010	2.530 2.510		
3	Lock Channel	0.094Inches + 0.004 - 0.001	0.098 0.093	Diameter	
4	Lock Channel	0.478Inches ± 0.010	0.488 0.468		
5	Lock Channel	1.256Inches + 0.005 - 0.001	1.261 1.255		
6	Lock Channel	0.197Inches ± 0.010	0.207 0.187	Diameter	
7	Lock Channel	2.750Inches ± 0.010	2.760 2.740		
8	Lock Channel	3.000Inches ± 0.010	3.010 2.990		
9	Lock Channel	0.050Inches ± 0.010	0.060 0.040		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

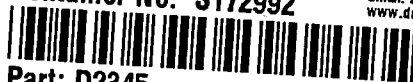
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S172992



Part: D2345

Job No: 192934

Serial No/Batch: S172992

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/16/19